**AMENDMENTS TO THE SPECIFICATION:**

Page 6

Please amend the fifth full paragraph as follows:

The invention also pertains to a chip removal machine 10, see Fig. 3, with a mechanical drive 6 for a tool 7 and/or a workpiece 1, regulated by a control system 5, wherein the regulation comprises a plurality of values C, X, Z of at least three spatial axes c, x, z for the control system 5 and for the drive 6, and the above-described method is used for determining the deviation of the regulating variables.

Page 7

Please amend the second, third and fourth full paragraphs on page 7 as follows:

**BRIEF DESCRIPTION OF THE DRAWINGS**

Additional benefits and details of the invention are discussed in the patent claims and in the specification, and presented in the figures. These show:

Figure 1, a representation of the differential values of a lens surface;

Figure 2, the representation of the z-value with the representation of the corresponding differential value; and[[.]]

Figure 3, one embodiment of a chip removal machine according to the present invention.

Please amend the full paragraph as follows:

## List of reference symbols

| | |
|---|---|
| 1 | workpiece |
| 2 | positive deviation |
| 2.1 | positive deviation of 1$^{st}$ degree |
| 2.2 | positive deviation of 2$^{nd}$ degree |
| 2.3 | positive deviation of 3$^{rd}$ degree |
| 3 | negative deviation |
| 3.1 | negative deviation of 1$^{st}$ degree |
| 3.2 | negative deviation of 2$^{nd}$ degree |
| 3.3 | negative deviation of 3$^{rd}$ degree |
| 4 | z-value |
| 5 | control system |
| 6 | mechanical drive |
| 7 | tool |
| 10 | chip removal machine |